



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2573
Job Sheet 170902



Part No: D2573
Part Name: Saddle, Aft, Out

Job Qty: 8 ea



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/23/18

Job Tracking No:

Due Date: 2/16/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 8 Ea		2/15/18	0.00	0.00	Start Up Machining		SBL 18/02/03
100	CNC Vertical Machining	12 8 pcs		2/15/18	1.01	10.00	HAAS 1		FK 18-2-7 / SBL 18/02/03
110	Mill Conv	12 8 pcs		2/15/18	0.00	1.00	Mill Conv 1		FK 18-2-7 / SBL 18/02/03
130	QC	12 8 pcs		2/15/18	0.00	0.00	QC8		mml 18/02/18
140	HandFinish	12 8 pcs		2/15/18	0.00	0.28	HandFinish1		18-02-12 8
150	Powdercoat	12 8 pcs		2/16/18	0.00	0.23	Powdercoat1		BK 18-02-13
160	QC	12 8 pcs		2/16/18	0.00	0.00	QC3		38
170	Packaging	12 8 pcs		2/16/18	0.00	0.00	Packaging3	5+358	DAG 21
180	QC21-SA	12 8 Ea		2/16/18	0.00	0.00	QC21		9-88 FEB 14 2018

Part Op 100 - Program Batch No.

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 11:10 O.U.T: 3:00 FINISH: 11:40 M 138467.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 8 Ea (1 ea)	90-Start up Operation	

5038648 & 5038659

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Aft Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Aft Outboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Aft Outboard	0.375Inches	0.380		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐																																																																																									
Date : _____		Step #: _____		QTY Effective _____																																																																																									
Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																													
Root Cause <table border="0" style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table border="0" style="width:100%;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> </table>						Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Pressure/Forced	☐	Temperature/Cure	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage/Defect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incomplete	☐	Marks/Chatter	☐	Drill Holes	☐
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OTHER : _____																																																																																													

S038662
**Saddle, Aft, Out**

PART NO: D2573
Original Serial #: S038662
Revision:
Operation: Start up Operation 02/03/18
Change No: Job No: 170902

Misaligned/off center	Turning Sequence	
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			+ 0.005	0.375
			- 0.000	
9	Saddle, Aft Outboard	0.490Inches	+ 0.020	0.510
			- 0.000	0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020	0.578
			- 0.000	0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010	1.375
			- 0.000	1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010	2.505
			- 0.000	2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010	4.129
			- 0.000	4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020	0.198
			- 0.000	0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040	3.250
			- 0.000	3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020	0.250
			- 0.000	0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005	0.313
			- 0.000	0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005	0.765
			- 0.000	0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020	0.372
			- 0.000	0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060	0.530
			- 0.000	0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020	0.635
			- 0.000	0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020	0.073
			- 0.000	0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020	1.520
			- 0.000	1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040	0.280
			- 0.000	0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure
Design	☐	Operator	Bending	☐	Set-up
Doc/Data	☐	Offset/Setup	Centre Not Concentric	☐	BOM/Route
Equip/Tooling	☐	Supplier	Cracks	☐	Broken/Damage/Defect
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material	☐	Use for Testing	Cuffs	☐	Contamination
Internal Transport	☐	Poor Information	Crushing	☐	Countersink
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Cut Too Short
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation	☐	Process Improvement	Marks/Chatter	☐	Drill Holes
Past Expiry Date	☐	Manufacturing Process			
Misidentified	☐	Past Due	OTHER :		

170902
~~171206~~

DART AEROSPACE LTD	Work Order:
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	8.000		
F	0.490	0.510		.498	.499	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.501	.500	.499		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.569	.569		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.370	1.375	min=1.370	1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.125	4.124	4.124	4.125		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.128	.125	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		.239	.241	.241	.240		
W	0.115	0.135		.124	.125	.124	.124		
X	0.308	0.313		.311	.310	.311	.311		
Y	0.760	0.765		.762	.762	.760	.760		
Z	0.352	0.372		.364	.368	.367	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.060	.063	.063	.063		
AD	0.240	0.260		.252	.250	.240	.251		
AE	1.500	1.520		1.512	1.512	1.513	1.513		
AF	0.115	0.135		.128	.125	.128	.125		
AG	0.240	0.280		.260	.255	.255	.253		
AH	0.240	0.260		.251	.249	.250	.252		
AI	2.000	2.020		2.003	2.002	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				✓	✓	✓	✓		

Measured by: <u>SBL 18/02/04 / MK</u>
Date: <u>18-2-04</u>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

170902
~~171266~~

DART AEROSPACE LTD		Work Order:
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.377	.377	.376	.376		
I	0.490	0.510		.501	.500	.501	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.125	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.125	.125	.125	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.242	.240		
W	0.115	0.135		.124	.125	.124	.123		
X	0.308	0.313		.310	.311	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.252	.251	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.255	.258	.260	.260		
AH	0.240	0.260		.249	.250	.249	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.037	.033	.033	.033		
Accept/Reject				✓	✓	✓	✓		

Measured by:	SBL / FR
Date:	18/02/05 18-2-6

Audited by:	mpj
Date:	18/02/12

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

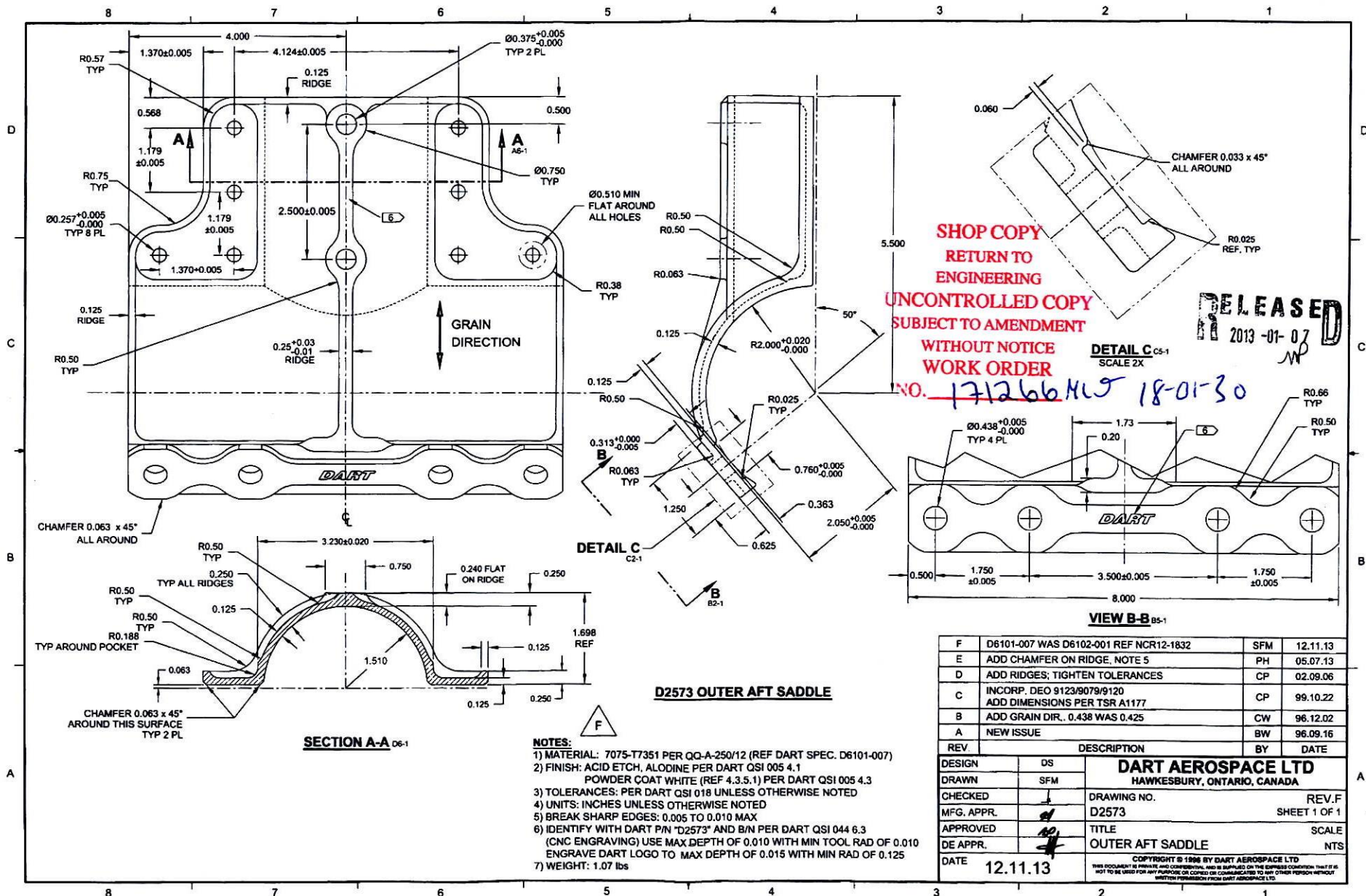
DART AEROSPACE LTD	Work Order: 170 902
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.001		
F	0.490	0.510		.500	.5000	.502	.498		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.502	.502	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.569	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.125	.124	.125		
R	0.240	0.260		.253	.253	.253	.251		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.224		
V	0.230	0.250		.241	.240	.240	.240		
W	0.115	0.135		.122	.125	.125	.125		
X	0.308	0.313		.310	.311	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.367	.365	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.251	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <u>FK / SBL</u>	Audited by: <u>MYL</u>
Date: <u>18-27 / 18/02/08</u>	Date: <u>18/02/12</u>

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : ☐			